

Work Order ID 70172

Monday, May 30, 2011 1:49:59 PM



Page 1

Item ID: D3391-025

Accept



Setup Start



Revision ID:

Item Name: Aft Tube Assembly

Stop



Start Date: 5/31/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: MF

Date: 11-05-30 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3391	Rev H/ DEO

100



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Mori Seiki CNC Lathe Large

Memo

0.00

Turn as per Folio FA599

Rev: 4A & Dwg D3391 Rev: H

M.M.L 11/06/06 1 Ø

scribe batch # on fwd end at 90 degree

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

Memo

0.00

on 11/06/06

1 Ø

111



QC8- Inspect parts - second check

QC

Quality Control

Memo

0.00

JUL 11/06/06 1 Ø

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

ark 11/06/07

[REDACTED] 11/06/08

1 0

HAAS CNC vertical machine #1

1-Machine as per Folio FA 599 Rev: *A* & Dwg D3391 Rev: *H*
2-Deburr

130



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

ark 11/06/07

1 0

Quality Control

140



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

A.A 11/06/08

1 0

Quality Control

W/O:		WORK ORDER CHANGES							
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Skidtubes

Skidtubes

Memo

0.00

0.00

160



BENDING MACHINE - SKIDTUBES

0.00

CNC Bend 1

Memo

CNC Delta 100 Bender

Form as per Dwg D3391 Using Bend Prog 3391025

0.00

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

W/O:		WORK ORDER CHANGES							
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Revision ID:							
Item Name:	Aft Tube Assembly				Stop		
Start Date:	5/31/2011	Start Qty:	1.00		Cust Item ID:		
Required Date:	6/10/2011	Req'd Qty:	1.00		Customer:		
Reference:							
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop		

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Open Aft cap pilot hole to .208" as per Dwg D3391								
	2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only)								
	3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig								
	*****Do Not Open To Finished Size*****								
	4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.								
	5-Open wearplate holes to 0.250" and c'bore as per dwg D3391								
	6-Open up all wearshoe , wearplate to 0.297"and float bag holes to 0.328" as per Dwg D3391.								
	7-Deburr								

11-6-8

BB
11/06/08

Dart Aerospace Ltd

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

S. Woblos

0.00



QC

Memo

(X)

Quality Control

200

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

(X)

B11/06/08

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

JP

11-6-8

Quality Control

Dart Aerospace Ltd

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220



Skidtubes

0.00

1

Skidtubes

Memo

0.00

Instal spacers as per dwg D3391
 A/R Magnabond 6398 Batch: 116677
 exp. date: 11/08
 cure time 12hrs as per QSI0015

230



QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

235



Pressure Wash per QSI005 4.3

0.00

1

HandFinish

Memo

0.00

Hand Finishing

AND REALODINE AS PER PAR09-043

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240



Powdercoat

M116964

Memo

10°30' 0.00
320° F

X Ø m / 11/06/09

250



QC

QC3- Inspect Part Finish

0.00

1 6 2010

Quality Control

Memo

0.00

260



HandFinish

HandFinishing

0.00

1 6 2010

Hand Finishing

Memo

0.00

- ✓1-Install inserts as per Dwg D3391
 - ✓2-Install Aft Cap as per Dwg D3391
- A/R Sikaflex-241/-291 M116945
Sikaflex expiry date: J2101

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

S woklog

280

Identify as per dwg & Stock Location: W10

0.00



Packaging

Packaging

P412-742-043/1369244

1 6 11/6/13

290

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

11/6/13 JF

MF
11-06-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 1

Work Order ID: 70172



Parent Item: D3391-025



Parent Item Name: Aft Tube Assembly

Start Date: 5/31/2011

Required Date: 6/10/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev B 06-02-07 ECN773 dwg rev. D EC
IPP Rev:C 06-03-28 Update Manuf. Instructions JLM □□ □□
IPP rev D 07.03.20 revF dwg EC
IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD
IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC
IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6014-090 		Manufactured	No			100	Each	7.0000	1	1			
ALUMINUM EXTRUSION													
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
							LG	7					
							(56572)	7					
D3670-4-200 		Manufactured	No			230	Each	59.0000	4	4		mm.l 11/6/11	
SPACER													
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
							LG	59					
							(68950)	59					
D2646 		Manufactured	No			270	Each	36.0000	1	1		3B 11/06/08	
Aft Cap													
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
							FP006	35					
							(62678)	35					X1
							FP-4	1					
							69019	1					

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Parent Item: D3391-025



Parent Item Name: Aft Tube Assembly

Start Date: 5/31/2011

Required Date: 6/10/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-1



Manufactured

No

270

Each

6.0000

1

1



all u localog

Wearpad

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP017	6	
63313	2	
66935	4	B68944

D3537-7



Manufactured

No

270

Each

4.0000

1

1



all u localog

Wearpad

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP017	4	
65146	4	

D3553-1



Manufactured

No

270

Each

16.0000

1

1



all u localog

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP013	16	
56568	16	

D3553-3



Manufactured

No

270

Each

40.0000

1

1



all u localog

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	20	
31631	20	
FP013	20	
53480	20	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
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Parent Item Name: Aft Tube Assembly

Start Date: 5/31/2011

Required Date: 6/10/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-1



Manufactured No

270

Each

1,204.000

2

2



el uloc108

Phenolic Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST074	1204	
64177	704	
66821	500	

ALS4-1032-130



Purchased No

260

Each

2,232.000

14

14



el uloc109

Insert

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST281	242	
117331	242	
ST282	1990	
117717	1990	

ALS4-1032-225



Purchased No

270

Each

1,437.000

12

12



el uloc108

Insert

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST282	1437	
110768	637	
117717	800	

AN3C4A



Purchased No

270

Each

2,361.000

6

6



el uloc108

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST350	2361	
117094	955	
117313	106	
117688	800	
117795	500	

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Start Date: 5/31/2011

Required Date: 6/10/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased No

270

Each

1,384.000

4

4



4411 location

Bolt

Location	Loc Qty	Loc Code
FP-A	7	
115835	7	
ST350	1377	
116419	220	
116549	57	X4
117343	500	
117508	300	
117764	300	

AN960C10L

NAS1149C0332

Purchased No

270

Each

0.0000

10

10

washer



4411724



4411 location

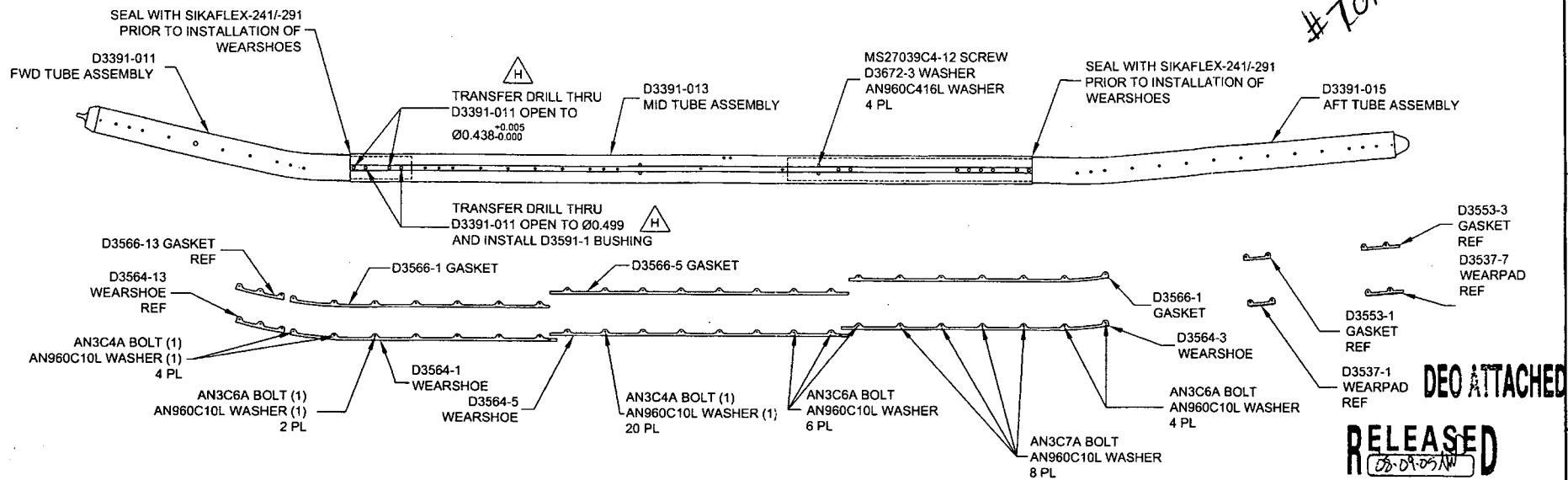
W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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#70172



DEO ATTACHED

RELEASED
08-08-20**D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
1	D3566-1	GASKET
2	D3566-5	GASKET
2	D3591-1	BUSHING
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. CBORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DS 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS. DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20		

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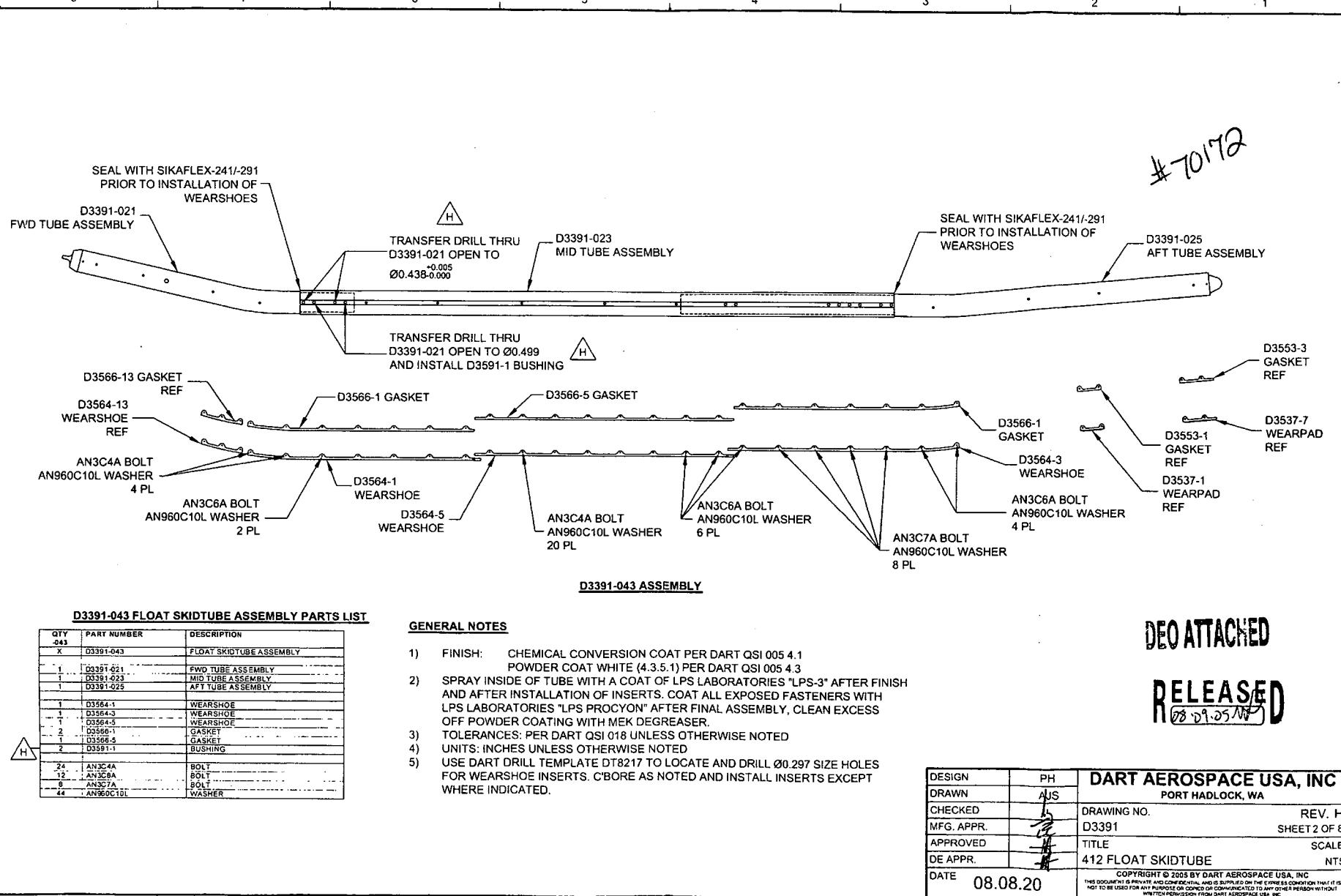
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



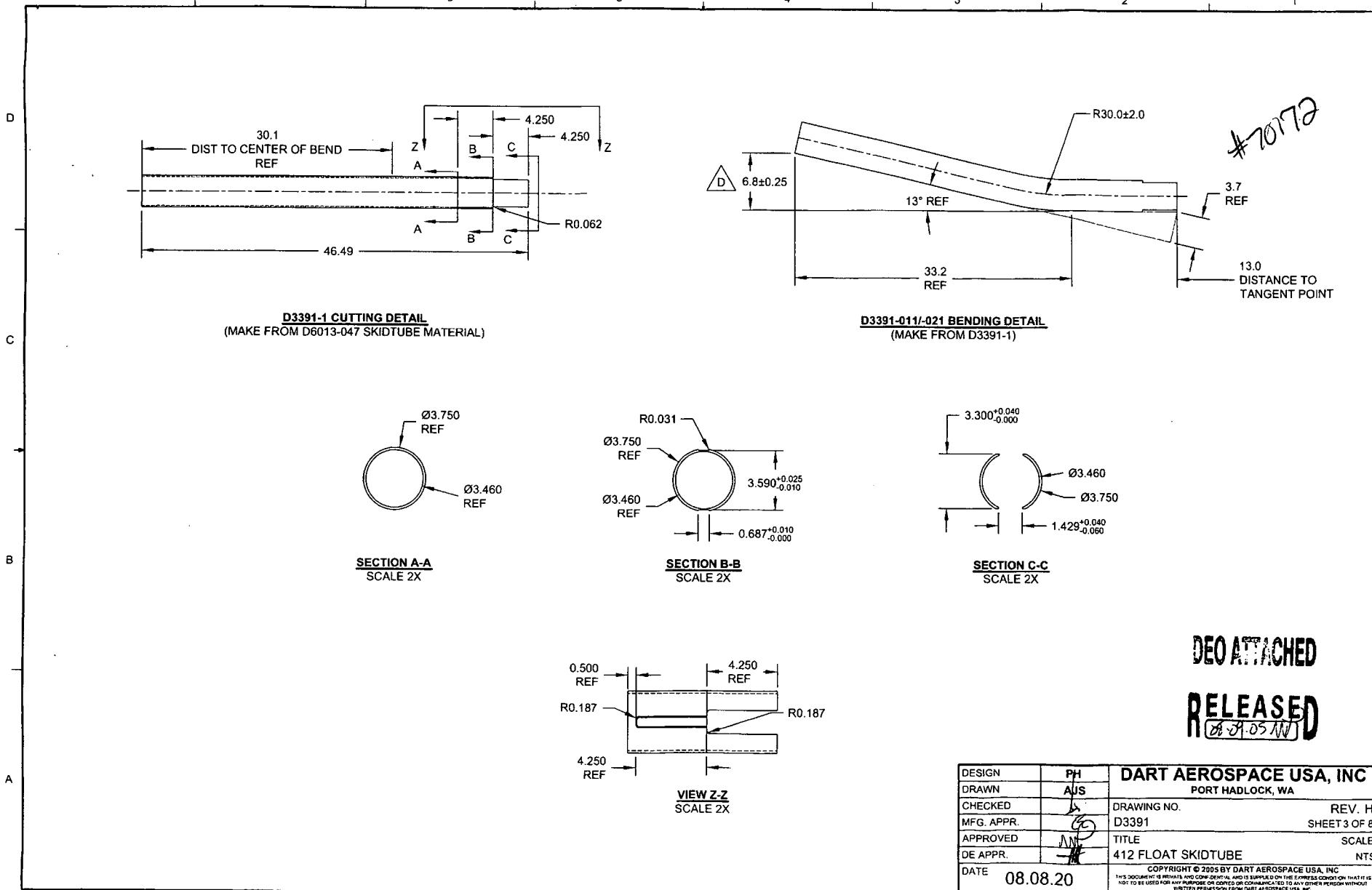
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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

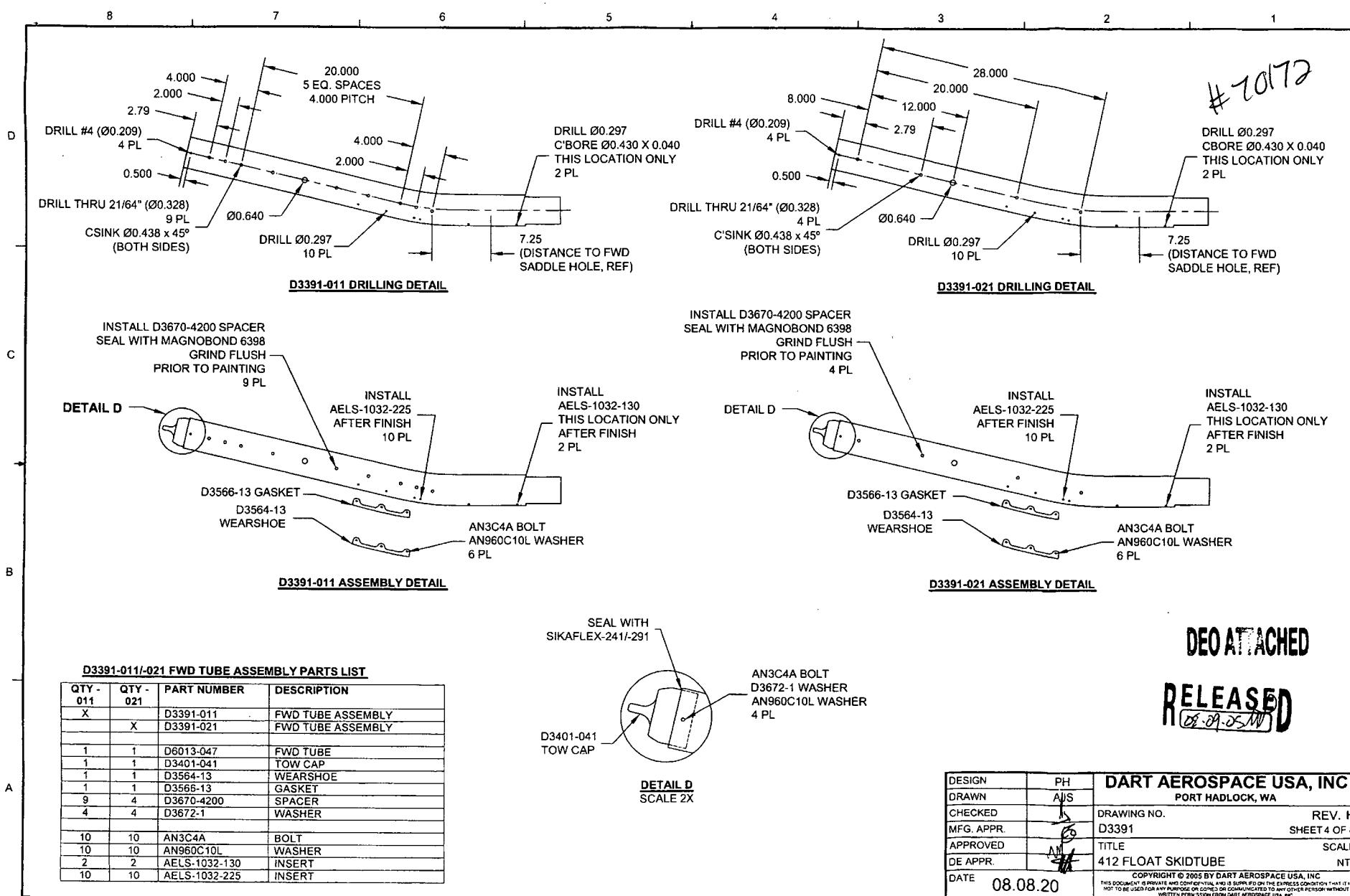
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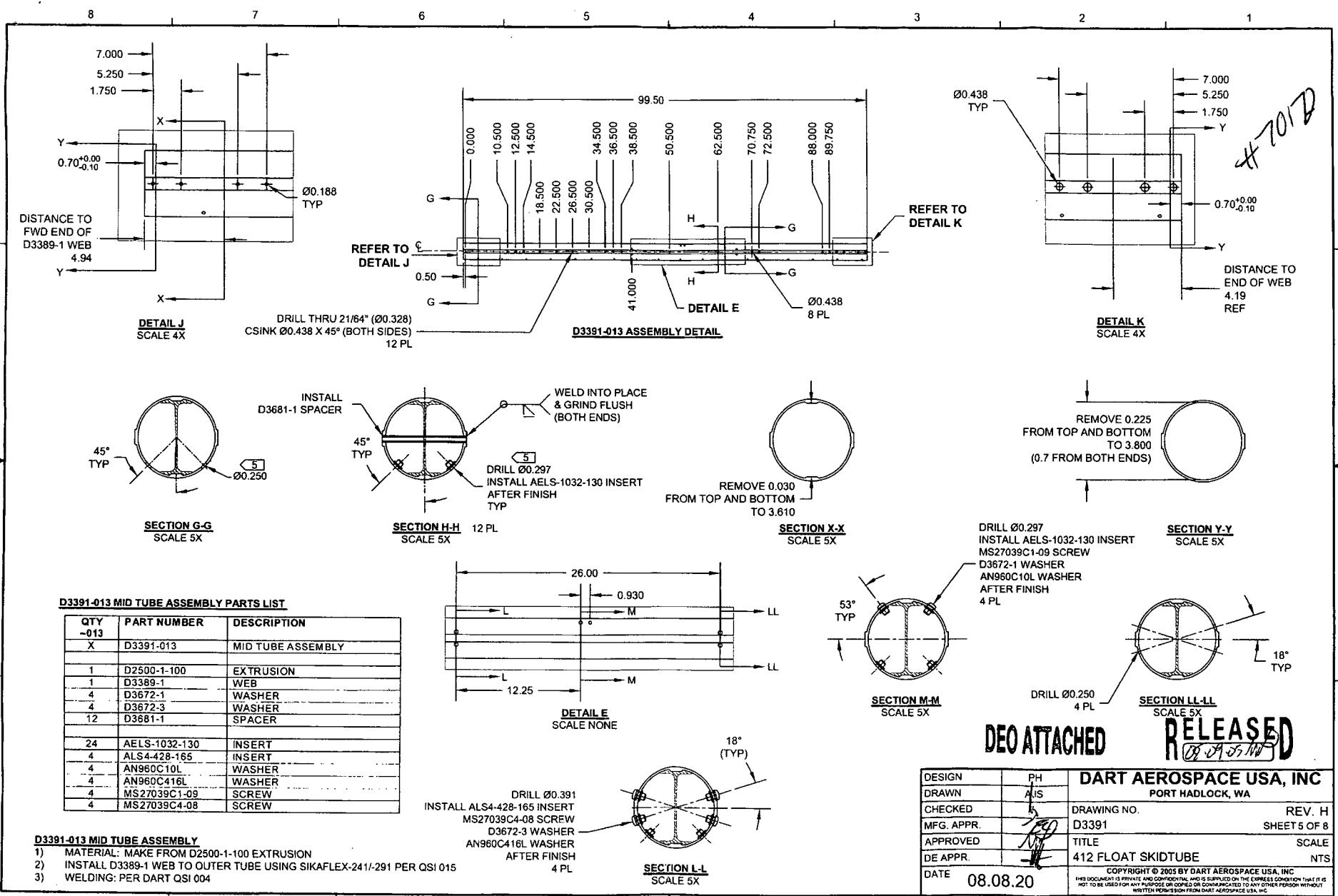
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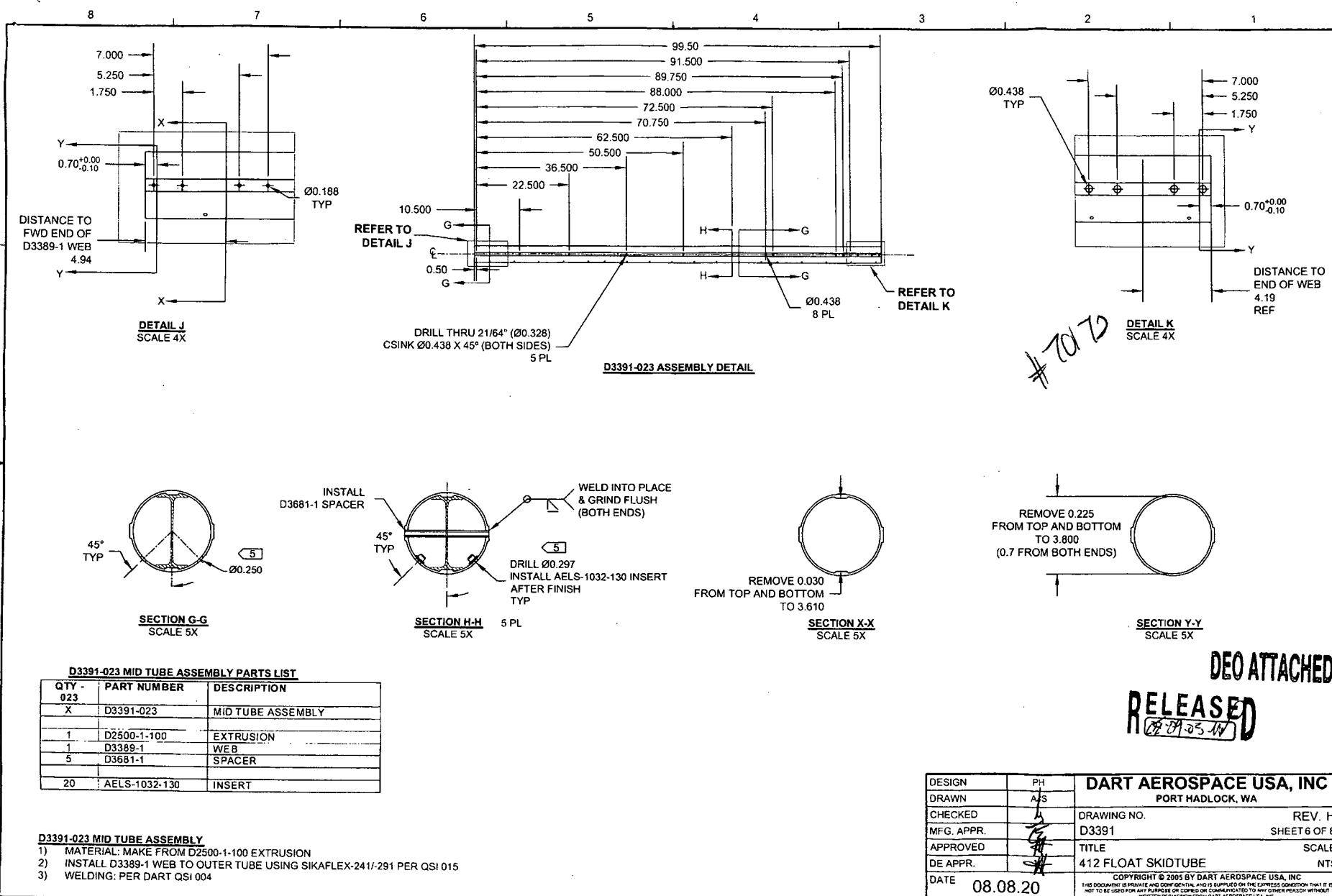
Dart Aerospace Ltd

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NOTE: Date & initial all entries



DET ATTACHED

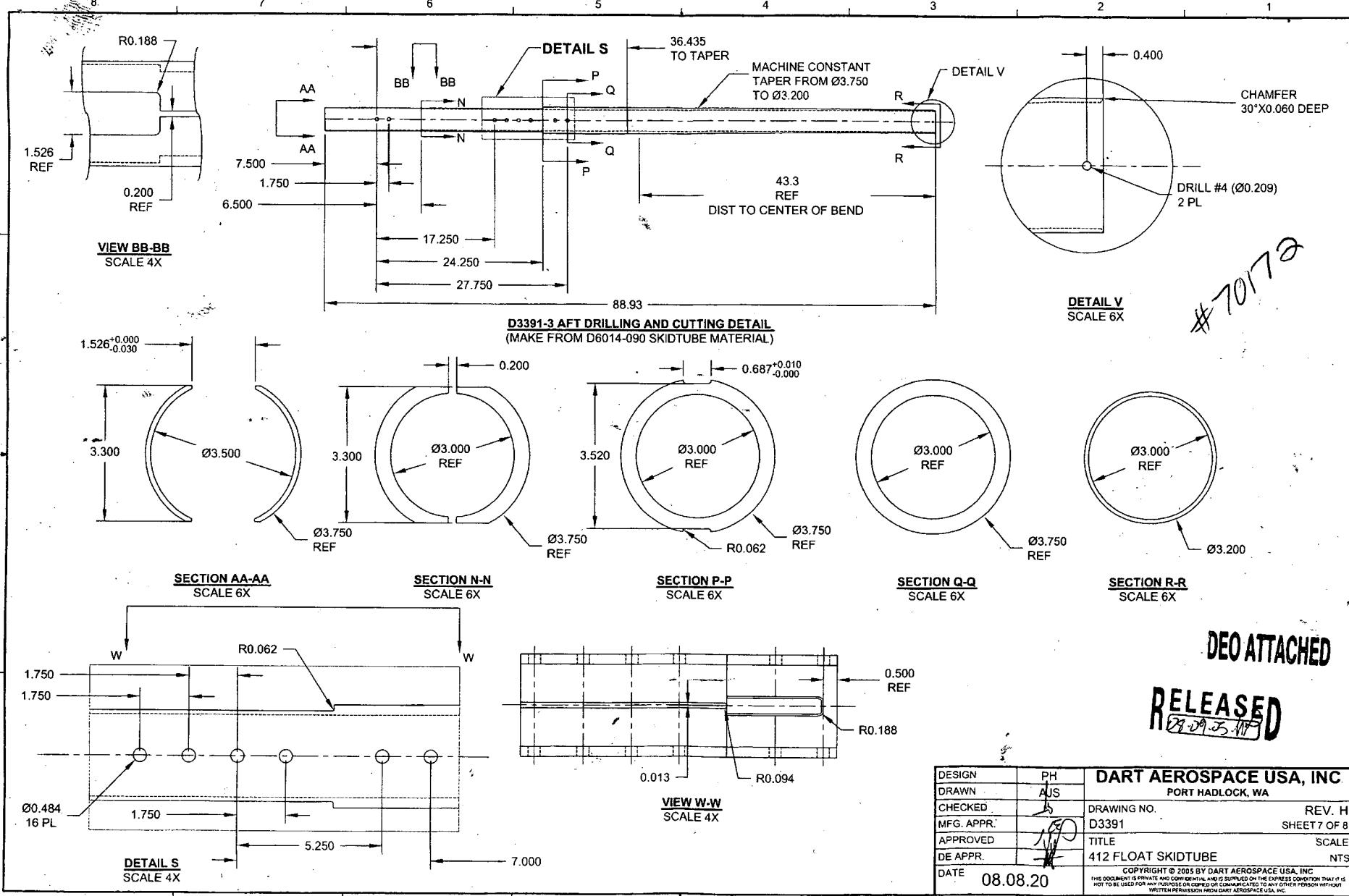
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 08.08.20

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DRAWN	AJS	PORT HADLOCK, WA
CHECKED		DRAWING NO.
MFG. APPR.		D3391
APPROVED		REV. H
DE APPR.		SHEET 7 OF 8
DATE	08.08.20	TITLE
		412 FLOAT SKIDTUBE
		NTS

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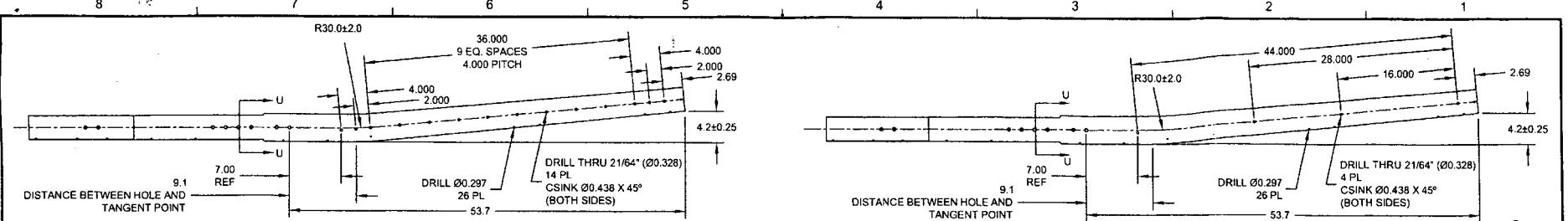
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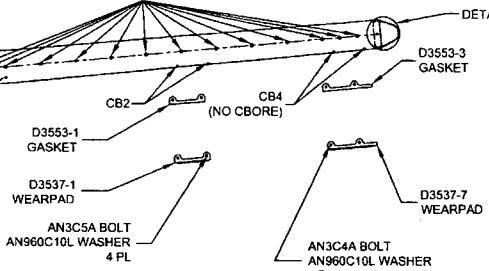
NOTE: Date & initial all entries



D3391-015 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)

INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6398
GRIND FLUSH
PRIOR TO PAINTING
14 PL

D3391-015 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)



D3391-025 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)

INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6398
GRIND FLUSH
PRIOR TO PAINTING
4 PL

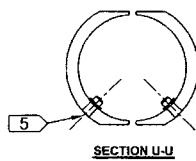
D3391-025 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

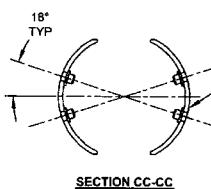
QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	D3391-015	AFT TUBE ASSEMBLY	
X	D3391-025	AFT TUBE ASSEMBLY	
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4		ALSA428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER

CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

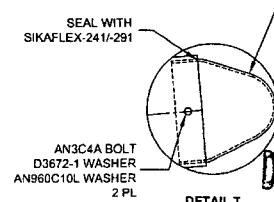


SECTION U-U
SCALE 3X



SECTION CC-CC
SCALE 3X

DRILL Ø0.391
CBORE Ø0.516 X 0.040 DEEP
INSTALL ALSA428-165 INSERT
4 PL



D3391-025 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)

DEO ATTACHED

RELEASED
08-09-05 M

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	A/S	PORT HADLOCK, WA	
CHECKED	✓	DRAWING NO.	REV. H
MFG. APPR.	✓	D3391	SHEET 8 OF 8
APPROVED	✓	TITLE	SCALE
DE APPR.	✓	412 FLOAT SKIDTUBE	NTS
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NOTE: Date & initial all entries

DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>JP</i>	CHECKED <i>JL</i>	MFG. APPR. <i>AA</i>	APPROVED <i>MP</i>	DE APPR. <i>TH</i>		
DATE 09.09.23	DATE 09.09.24	DATE 09/09/25	DATE 09/09/30	DATE 09/09/30	DATE 09/09/30	

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.~~ COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

R E L E A S E D
2010 -02- 02

MP
**10/17*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	10172
Description: Float Skidtube (412)		Part Number:	D3391-3
Inspection Dwg: D3391	Rev: H		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.000	/		tape	EC-11
3.500	+/-0.010	3.5041	✓		vern	JF-01
88.93	+/-0.030	88.93	✓		tape	EC-11
44.995	+/-0.030	44.995	✓		tape	MM-L-02
Ø3.200	+/-0.010	3.199	✓		micr	CNC-05
88.93	+/-0.030	88.93	✓		tape	EC-11
Ø3.750	+/-0.010	3.749	✓		micr	CNC-05
30° x 160"	+/-0.010	30° x 160	✓			
chamfer						

Measured by: *MPL* Date: 11/06/03

Audited by: *[Signature]* Date: 11/06/03

HAAS Section						
1.526	+0.000/-0.030		1.520	-	Vern M1-7	
7.500	+/-0.010		7.500	-	"	
27.750	+/-0.010		27.750	-	M-tape M1-2	
31.750	+/-0.010		31.750	-	"	
35.250	+/-0.010		35.250	-	"	
3.300	+/-0.010		3.307	-	Vern M1-7	
0.200	+/-0.010		0.204	-	"	
3.520	+/-0.010		3.524	-	"	
0.687	+0.010/-0.000		0.687	-	"	
R0.062	+/-0.010		R.062	-	R-G	
Ø0.484	+0.005/-0.001		Ø.489	-	Vern M1-7	

Measured by: *MPL* Date: 11/06/08

Audited by: *B.A.* Date: 11/06/08

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	<i>SK</i> <i>AM</i>

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E: Date & initial all entries